

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018101**Date Inspected:** 09-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen, Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10, OBG BIKE PATH, END PLATE (NWIT # 07284)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A1-030-043, 044

BAY 11, OBG BIKE PATH, BOTTOM COVER PLATE (NWIT # 07287)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A2-020-016, 018

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BAY 11, OBG BIKE PATH (NWIT # 07289)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK005B4-004-014, 015

BK005B7-004-025, 026, 031, 032, 085, 086, 091, 092

BK005B3-004-025, 026

BK005B7-004-001, 002, 007, 008, 061, 062, 067, 068

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

TOWER FACADE PLATE

FCAW welding of weld joints 001 & 002 located on ND1-SFSA4-041.

Welder is identified as 040365. ZPMC QC is identified as Mr. Yin Chun Fang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

SMAW welding of weld joints 004 & 005 located on ND1-SFSA4-018.

Welders are identified as 050038 & 056200. ZPMC QC is identified as Mr. Yin Chun Fang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

OBG BIKE PATH, VERTICAL ANCHOR HOUSE PLATE

SMAW welding of weld joints 003 & 005 located on BK004A6-025.

Welder is identified as 052493. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

SMAW welding of weld joints 025 & 027 located on BK004A6-025.

Welder is identified as 052493. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

BAY 11

TOWER BRACKET

SMAW welding of weld joint 006A located on ND1-BRSA5-1.

Welder is identified as 044541. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b.

TOWER LIFT 6, SKIN "A" SUBASSEMBLY

FCAW welding of weld joint 005 & 006 located on WSD1-FASA6-4.

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Welder is identified as 053316. ZPMC QC is identified as Mr. Shao Hai Lang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

OBG BIKE PATH, CENTRE PLATE

SMAW welding of weld joint 015 & 016 located on BK004C8-024.

Welder is identified as 040655. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372/ Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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